

Work Order ID 78169

78169

Page 1

January-02-12 8:13:35 AM

Item ID: D3562-042

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly, RH

Start Date: 02/01/2012 Start Qty: 4.00

Required Date: 31/01/2012 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: M.L.J

Date: 12/01/02 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3562

Rev E

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622 extrusion as per Dwg D3562
2-Deburr and bevel ends for welding

110

0.00

110

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

120

0.00

120

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

to 12.01.17

Cpl 12.01.18

K 12.01.23

(x5)

Ø

54 Ø

5 Ø

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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January-02-12 8:13:35 AM

Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, RH
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------------|
| 130 *130* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | <i>12/22/07</i> (5) |
| 140 *140* Small Fab Small Fab | Small Fab Memo 1- Drill Rivet holes as per dwg D3562. Touch up alodine 2- Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: <i>117870</i> | 0.00 0.00 | | | | | | | <i>12-22-07</i> 5 <i>PTC</i> |
| 150 *150* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | <i>12/26/07</i> 45 <i>14.</i> |

| W/O: 78169 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3562-042 PAR #: Fault Category: Long Pass/Steps NCR: Yes No DQA: Date: 12/2/14
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 12/2/14

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| 12.02.07 | 140 | Rivets were defective did not enlarge enough which caused trying to fix which enlarged holes | 12.02.07 GSI042 | rework made new qty 45 step and new arm and new rivets new arm part # 79088 +1 new step part # 77612 +1 | 12.02.07 K | S 12/2/08 | 12.02.07 GSI042 | S Blaker |
| | | R.C. Supplier | | D3560-044 B # 79098 D3562-1 B77612 | | | | |
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 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | | 0.00 | | | | | | | |
| *160* | Large Fab | | | | | 5 | 0 | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>114514</u> 2-Grind end cap welds flush as per Dwg D3562 → Re 12/02/07 | | | | | | | | |
| 170 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 180 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(X)
RH

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, RH
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Run Start ***NR1***
 Stop ***NR2***
 Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 190 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

| | | | | | | | | | |
|----------------|--|------|--|--|--|--|--|--|--|
| 200 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

| | | | | | | | | | |
|----------------|---------------------------------------|------|--|--|--|--|--|--|--|
| 210 | Wing Walk as per dwg QSI005 4.4 Batch | 0.00 | | | | | | | |
| *210* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

m11a480

3:50
 START TIME: 3:50
 OVEN TEMPERATURE: 320
 FINISH TIME: 4:20

SXDM-12/02/08

5 BL 10-2-8

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3562-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, RH
 Start Date: 02/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|--|
| 220 *220* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | | | | 5RH 8 M 12/02/10 counted & identified |
| 230 *230* Packaging Packaging | Identify as per dwg & Stock Location Memo | 0.00 0.00 | | | | | | | 6-A w/o 78166 |
| 240 *240* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 12/2/13 12-02-13 CS |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-02-12 8:13:39 AM

Page 1

Work Order ID: 78169

78169

Parent Item: D3562-042

D3562-042

Parent Item Name: Step Assembly, RH

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by: EC
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2622-120C

Manufactured No

100

Each

86.0200

1

4

D2622-120C

Step Extrusion

**

Ac 12.01.17

Location

Loc Qty

Loc Code

HALL

17.02

46910

2

64409

6

66970

7.7

68293

0.5

72131

0.82

WA013

69

75781

69

D2734

Manufactured No

140

Each

144.0000

2

8

D2734

Step End Plate

**

12.01.07

Location

Loc Qty

Loc Code

WA

135

76985

135

WA015

9

73416

9

D3560-042

Manufactured No

140

Each

0.0000

1

4

D3560-042

Arm Weldment

**

12.02.01

*B-71933 = 2
 B-79084 = 3*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-02-12 8:13:39 AM

Page 2

Work Order ID: 78169

78169

Parent Item: D3562-042

D3562-042


Parent Item Name: Step Assembly, RH

Start Date: 02/01/2012

Required Date: 31/01/2012

Start Qty: 4.00

Required Qty: 4.00

 D3560-044
D3560-044
Arm Weldment

Manufactured No

B79088=1
B78332=2
B71950=2

140

Each

3.0000

1

4

**

12.02.01

*scraped 1
originally took 3*

Location

Loc Qty

Loc Code

WA013

3

71950

3

160

Each


487.0000

32

128

**

12.02.07

 MS20600-AD4W5
MS20600-AD4W5
Blind Rivet

Purchased

No

Location

Loc Qty

Loc Code

ST321

1116289

481

114382

173

117505

82

118384

226

WA018

1120142

6

111477

6

1120510

15

*100
13*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

D3560-043 ARM WELDMENT

D3560-041 ARM WELDMENT

D3560-044 ARM WELDMENT

D3560-042 ARM WELDMENT

D3562-1,
MAKE FROM
EXTRUSION D2622

2
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

TRANSFER DRILL #30
DEBURR & TOUCH UP HOLES
WITH CHEMICAL CONVERSION
COAT BEFORE RIVETING
(32 PLACES PER STEP)

REFER TO STEP
END DETAIL

INSTALL MS20600AD4W5 RIVET
(32 PLACES PER STEP)

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100%
VISUALLY INSPECTED BY A
QUALIFIED INSPECTOR PER
DART QSI 004

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 78169 M.C.J
12/01/02

D2734 END PLATE
(TYP 2 PLACES)
TYPICAL STEP END DETAIL
SCALE 1:2

D3562-041 LH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A

2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION

PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR

GREY SANDTEX (4.3.5.6) OR

BLACK SANDTEX (4.3.5.7) OR

GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN
THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

| QTY -041 | QTY -042 | P/N | DESCRIPTION |
|-------------|-------------|--------------|------------------|
| X | | D3562-041 | LH STEP ASSEMBLY |
| | X | D3562-042 | RH STEP ASSEMBLY |
| 1 | | D3560-041 | ARM WELDMENT |
| | 1 | D3560-042 | ARM WELDMENT |
| 1 | | D3560-043 | ARM WELDMENT |
| | 1 | D3560-044 | ARM WELDMENT |
| 32 | 32 | MS20600AD4W5 | RIVET |
| 2 | 2 | D2734 | END PLATE |

D3562-042 RH STEP ASSEMBLY

| | | | |
|------|--|----|----------|
| REV. | DESCRIPTION | BY | DATE |
| E | ADD QTY (2) TO D2734 END PLATE ON D3562-042 | PH | 08.01.11 |
| D | REMOVE D2800 SPACER NOTE; REDRAWN IN SOLIDWORKS | DC | 07.11.16 |
| C | NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS | CP | 07.06.19 |
| B | ARMS NOW RIVETED TO STEP | CP | 07.01.15 |
| A | NEW ISSUE | CP | 06.09.26 |

| | | | |
|------------|----|---|--------------|
| DESIGN | 90 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | 64 | | |
| CHECKED | 16 | DRAWING NO. D3562 | REV. E |
| MFG. APPR. | | SHEET 1 OF 1 | |
| APPROVED | | TITLE STEP ASSEMBLY | SCALE 1:5 |
| DE APPR. | | DATE 08.01.11 | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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